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D4030-041
Job Sheet 185678



Part No: D4030-041

Job Qty: 1 ea

Part Name: Long Basket Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Stores/Pkg-1		BQ 18-11-27
100	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging1-4		M 18-11-27
110	HandFinish	1 pcs	11/23/18	11/23/18	0.00	1.03	HandFinish4		M 18-11-27
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		NOV 28 2018 68
130	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		NOV 28 2018 9-89
140	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		NOV 28 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068652
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5689276
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5121225
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5103950
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5113819
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5112904
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5115080
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5121157
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5115452
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5124370
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5108609
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5117415
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5112317
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5118041
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5115826
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5115399
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5117430
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5094592
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5083541
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	5053951
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5104465
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5050052-1
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5109991

DQA: _____ Date: _____

MAIL
11 Jul 2019



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

QA Closed: _____ Date: _____

Work Order: <u>18638</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS						Engineering Quality ☒					
Part No. <u>D4830-011</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing Composite ☐		Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐		Quality Other ☐					
NCR No. <u>19-7311</u>		Suspected Unapproved		QTY Effective:		Disposition		MRB (QS1042) Approval		12 9/19/15					
Date: <u>18/11/28</u>		Step #:		QTY Effective:		Disposition		Completed By <u>15</u> 9-89		Lead hand / Supervisor Approval Verification					
Description Work Order Deviation				Replace with AN3-15A Ref. AR 18-281 (update drug)								QC / QA Coordinator Approval <u>55</u> 9-89 19-7-11			
AN3-14A b.15 used for pop ^{arm} are too short. Not enough threads in safety.															
Root Cause				FAULT CATEGORY											
Environment				No Re-verification				Pressure/Forced				Positioned Wrong			
Design				Operator				Bending				Outside Dimensions			
Doc/Data				Offset/Setup				Centre Not Concentric				Over/Under tolerance			
Equip/Tooling				Supplier				Cracks				Part Incorrect			
Handling/Pre				Training				Crimp/Kink/Ripple/Wave				Part Lost/Missing			
Material				Use for Testing				Cuffs				Part Moved			
Internal Transport				Poor Information				Crushing				Drawing			
Tribal Knowledge				Pushing				Heat Treat				Finish			
LOA				Product Improvement				Wave/Twist in Tube				Misread			
Substation				Process Improvement				Marks/Chatter				Turning Sequence			
Past Expiry Date				Manufacturing Process				OTHER:							
Misidentified				Past Due											

NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation	5083558-1
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5067901-2
D3913-041	Long Basket Base Assembly, 350	1 Ea (1 ea)	110-HandFinish	5129834
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	110-HandFinish	5129656

Job Allocations					006717
Operation	Component Part	Required	Inventory	Allocated	
90-Start up Operation	AN3-14A	4	318	0	
	AN3-16A	2	84	0	
	AN310-4	3	134	0	
	AN310C4	2	104	0	
	AN4-12	3	173	0	
	AN5-17A	4	101	0	
	D2530	1	13	0	
	D2535	2	59	0	
	D2537	2	40	0	
	D3917-3	6	30	0	
	D3953-17	2	47	0	
	D3953-19	1	32	0	
	D3953-21	1	19	0	
	D3953-3	2	36	0	
	D3953-7	2	88	0	
	D3953-9	2	42	0	
	D3969-3	1	14	0	
	MS21042L3	6	2,363	0	
	MS21042L5	4	531	0	
	MS24665-151	3	154	0	
	MS24665-300	2	89	0	
	NAS1149C0432R	2	1,970	0	
	NAS1149F0332P	8	2,093	0	
	NAS1149F0432P	6	678	0	
	NAS1149F0563P	4	757	0	
110-HandFinish	D3913-041	1	4	0	
	D3914-041	1	7	0	

Part Specifications				
Specifications could not be found.				



Container No: S131877

Part: D4030--041
Job No: 185678
Serial No/Batch: S131877
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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www.dartaerospace.com

Date: 11/27/18

Plex 10/31/18 11:37 AM Dart.lajeunesse.marie

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____				MRB (QS1042) Approval			
Description Work Order Deviation		Disposition				Completed By			
						Lead hand / Supervisor Approval Verification			
						QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER : _____					